

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017117**Date Inspected:** 18-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Gong Wai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Out Side Yard

This QA Inspector observed the following work in progress:

FCAW in the 3F position for the OBG segment 12BE, weld No. SEG3002E-058~095. The welder is identified as #068501. ZPMC QC is identified as Mr.Li Ping . The welding variables recorded by QC appear to comply with WPS-B-T-2133.

FCAW in the 2F position for the OBG segment 12BE, weld No. SEG3002E-022~039. The welder is identified as #068501. ZPMC QC is identified as Mr.Li Ping . The welding variables recorded by QC appear to comply with WPS-B-T-2132-3.

Bay#14

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG segment 13AE, weld No.KP3006-001-003. The welder is identified as #067079. ZPMC QC is identified as Mr.Wang Xu . The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4B-F.

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FCAW in the 2G position for the OBG segment 13BE, weld No.VP3004-001-007. The welder is identified as #066439. ZPMC QC is identified as Mr.Zhang Lin. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4B-F.

FCAW in the 2G position for the OBG segment 13BE, UT repair, weld No.KP3005-001-004. The welder is identified as #044795. ZPMC QC is identified as Mr.Zhang Lin. The welding variables recorded by QC appear to comply with WPS-345-FCAW-2G(2F)-FCM-REPAIR. Weld repair report is identified as CWR1928.

SMAW in the 1G position for the OBG segment 13AE, Base metal MT repair, Bottom Plate No. BP3030-001. The welder is identified as #048047. ZPMC QC is identified as Mr.Guo Xing Hui. The welding variables recorded by QC appear to comply with WPS-345-SMAW-1G(1F)-REPAIR. Weld repair report is identified as CWR1833.

Bay#19

This QA Inspector observed the following work in progress:

FCAW in the 4G position for the OBG bike path, weld No. BK004A6-010-070. The welder is identified as #058792. ZPMC QC is identified as Mr. Li Ming Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2334-Tc-P4-F.

FCAW in the 3G position for the OBG bike path, weld No. BK004A6-012-060. The welder is identified as #062761. ZPMC QC is identified as Mr. Li Ming Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2333-Tc-P4-F.

FCAW in the 2F position for the OBG bike path, weld No. BK004A3-013-025. The welder is identified as #062807. ZPMC QC is identified as Mr. Li Ming Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

FCAW in the 2F position for the OBG bike path, weld No. BK004A4-014-014. The welder is identified as #062761. ZPMC QC is identified as Mr. Li Ming Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

Magnetic Particle Testing (MPT) for Base metal repair Area

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG segment 13BW bottom plate stiffener base metal repair. This QA inspector generated a (MT) report for this date .This area was previously tested and accepted by ZPMC QC MT technicians.

The bottom plate member Designations are as follows

BP3058,BP3059,BP3061,BP3062

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

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documents.



## Summary of Conversations:

No relevant conversations

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Bera,Subhasis	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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